

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021319**Date Inspected:** 02-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

This QA Inspector observed the following work in progress:

OBG Seg 14W:

The Flux Cored Arc Welding (FCAW) process on weld joint no: FB3329-001-018 [X4934A to X4934C of Floor Beam (FB) 3329A, fillet weld at panel point (PP) 127]. The welder is identified as 066673 and was observed welding in 2F position. ZPMC Quality Control (QC) was identified as An Qing Xiang. The welding variables recorded by this QC appeared to comply with Welding Procedure Specification (WPS): B-T-2132-ESAB.

Repair welding of weld joint no: Seg3020AL-003 [Bottom Panel (BP) 3094A to FB3317A, CJP weld, at PP125]. The welder is identified as 067707 and was observed welding in the 2G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): 18585 Rev-1.

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Repair welding of weld joint no: Seg3020BB-073 (Sub Assembly Vertical Shear Plate to BP, CJP weld). The welder is identified as 067942 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per Critical Welding Repair Report (CWR): B-CWR-2752 Rev-2.

Repair welding of weld joint no: Seg3020Y-031 [Longitudinal Diaphragm (LD) 3051A to BP3090A, CJP weld, between PP127.3 and PP127.5]. The welder is identified as 067942 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per CWR: B-CWR-6622 Rev-4.

OBG Seg 13AW:

The FCAW process on weld joint no: Seg3013AA-113 [Sub Assembly (SA) 3188A to Edge Plate (EP) 3023A, CJP weld at PP118]. The welder is identified as 066912 and was observed welding in 2G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

East Saddle Grillage – West line:

Repair welding of weld joint nos: SA7512C-257 and 258, CJP weld. The welder is identified as 045196 and was observed welding in the 2G and 4G positions; for the respective welds. Welding process was identified as SMAW. ZPMC QC was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair and 345-SMAW-4G(4F)-FCM-Repair, respectively. Repair welding was done as per CWR: B-CWR-2629 Rev-5.

This QA Inspector observed ZPMC personnel performing fit-up of X4391 stiffeners with Floor Beam (at PP119, PP119-1500 and PP119+1500) and Grillage Assembly. Ultrasonic Testing (UT) of FB to Grillage welds is still outstanding. See attached photo for further information.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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| Inspected By: | Wadkar,Sailesh |
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| Quality Assurance Inspector |
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| Reviewed By: | Peterson,Art |
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| QA Reviewer |
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